



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2893-1

Job Sheet 185477



Part No: D2893-1

Job Qty: 10 ea

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/26/18

Job Tracking No:

Due Date: 11/9/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV C IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15 add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining-1		mm
100	CNC Vertical Machining	10 pcs	11/9/18	11/9/18	0.33	19.61	HAAS1-2		mm
120	QC	10 pcs	11/9/18	11/9/18	0.00	0.00	QC8 Machining-1		mm
130	Crosstubes	10 pcs	11/9/18	11/9/18	0.00	1.67	Crosstubes-2		mm
140	QC	10 pcs	11/9/18	11/9/18	0.00	0.00	QC3		mm
170	Packaging	10 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1	LG050	mm
180	QC21-SA	10 Ea	11/9/18	11/9/18	0.00	0.00	QC21		mm

Part Op 100 - 1-Machine as per Folio FA081

Descriptions: 130 - Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg.

170 - LOCATION : LG050 138852 exp 7/19

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK078	D2893-1 Turning Detail	5 Ea (.5 ea)	90-Start up Operation	5125173 → 5x

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	DSK078	5	0	0

38
18-2

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches + 0.020 - 0.000	3.005 2.985		
2	2.750 Support	0.440Inches + 0.020 - 0.000	0.460 0.440		
3	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
4	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
5	2.750 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
6	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
7	2.750 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
8	2.750 Support	1.360Inches + 0.040 - 0.000	1.400 1.360		
9	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
10	2.750 Support	1.190Inches + 0.040 - 0.000	1.230 1.190		
11	2.750 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
12	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
13	2.750 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
14	2.750 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
15	2.750 Support	84.390Inches + 6.000 - 0.000	90.390 84.390		
16	2.750 Support	0.261Inches + 0.005 - 0.000	0.266 0.261		
17	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		

Plex 10/26/18 2:33 PM dart.white.jesse

DART
 AEROSPACE
 Container No: S126958
 Part: D2893-1
 Job No: 185477
 Serial No/Batch: S126958
 Revision:
 Inspector:
 Exp Date:
 Instructions: Various STC's
 Date: 11/12/18

1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

DART AEROSPACE LTD		Work Order:	
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893		Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.994	2.997	2.994	2.999	2.999
AB	0.440	0.460		.458	.459	.457	.456	.455
AC	0.125	0.160		.158	.158	.159	.159	.158
AD	0.040	0.060		.047	.046	.050	.049	.048
AE	0.188	0.193		.189Ø	.189Ø	.189Ø	.189Ø	.189Ø
AF	0.125	0.160		.135	.136	.138	.138	.136
AG	0.140	0.160		.151	.152	.152	.153	.152
AH	1.360	1.400		1.375	1.376	1.373	1.374	1.375
AI	0.040	0.060		.048	.047	.049	.049	.049
AJ	1.190	1.230		1.215	1.215	1.213	1.214	1.213
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063 R	.063 R	.063 R	.063 R	.063 R
AM	0.240	0.260		.250 R	.250 R	.250 R	.250 R	.250 R
AN	2.518	2.538		2.525	2.536	2.534	2.535	2.536
AO	84.39	90.39		87.00°	87.00°	87.00°	87.00°	87.00°
AP	0.261	0.266		.260Ø	.260Ø	.260Ø	.260Ø	.260Ø
AQ	0.053	0.073		.063 R	.063 R	.063 R	.063 R	.063 R
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>M.M.</i>	Date:	2018/11/12
Audited by:	<i>mmL</i>	Date:	18/11/13
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893		Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	2.985	3.005		2.999	2.998	2.998	2.998	2.998
AB	0.440	0.460		.456	.450	.450	.450	.450
AC	0.125	0.160		.159	.159	.159	.159	.159
AD	0.040	0.060		.048	.048	.048	.048	.048
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.137	.138	.139	.137	.136
AG	0.140	0.160		.154	.151	.152	.150	.150
AH	1.360	1.400		1.374	1.375	1.375	1.375	1.375
AI	0.040	0.060		.049	.042	.044	.042	.043
AJ	1.190	1.230		1.214	1.211	1.210	1.208	1.210
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063 R	.063	.063	.063	.063
AM	0.240	0.260		.250 R	.250	.250	.250	.250
AN	2.518	2.538		2.536	2.526	2.528	2.526	2.528
AO	84.39	90.39		87.20°	87.39°	87.39°	87.39°	87.39°
AP	0.261	0.266		.260	.261	.261	.261	.261
AQ	0.053	0.073		.063 R	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>M.M. [Signature]</i>	Date:	2018/11/12
Audited by:	<i>mm L</i>	Date:	18/11/13
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	<i>[Signature]</i>

